

Date: Friday, 9/7/2007 10:14:31 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34460 -1
Estimate Number : 12362
P.O. Number : N/A
This Issue : 9/7/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : 30774
Written By : 7/09/07
Checked & Approved By : 7/09/07
Comment : Est Rev:A New Issue 06-04-11 JLM

Drawing Name : TAIL LIGHT FAIRING
Part Number : D34845
Drawing Number : D3484 REV D
Project Number : N/A
Drawing Revision : D
Material : N/A
Due Date : 9/14/2007

Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 0.2904 sf(s)/Unit Total : 2.9043 sf(s)

6061-T6 .050 Sheet

(M6061T6S050)

Batch: 717347

Qty = 10

Scrap = 1
Total = 11

SAD 07/09/08

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
Cut as per Dwg D3484

Dwg. D

Prog. D

SAD 07/09/08

10

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/08

10

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 07/09/10

10

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD 07/09/13

10

2-Roll as per Dwg D3484

FF 07-12-13

P70

X6

STATED

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/08	20	One part scrap. Had to change offset to 0.020 to get in tolerance Part is 0.013" too small on the width.	<i>[Signature]</i>	Scrap, destroy, replace part acceptable.	SAB 17/08/08	<i>[Signature]</i> 17-9/10	<i>[Signature]</i>	<i>[Signature]</i> 07/12/18
07/11/13	5	TOOK 3 part of the w/o D 3484-2 (3484) Bath # of material to make material part equal -1 & -2	<i>[Signature]</i>	acceptable	<i>[Signature]</i>	SAB 07/12/13	<i>[Signature]</i>	<i>[Signature]</i> 11-12-13
07/11/08	5	Scrap 4 parts		Need a jig	<i>[Signature]</i> 07/11/08			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 34460

Part Number: D34845

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 2/12/13 (x7)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LS*

PD 07-12-17 (7)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(7) 12/12/18

Job Completion



run 12/12/17

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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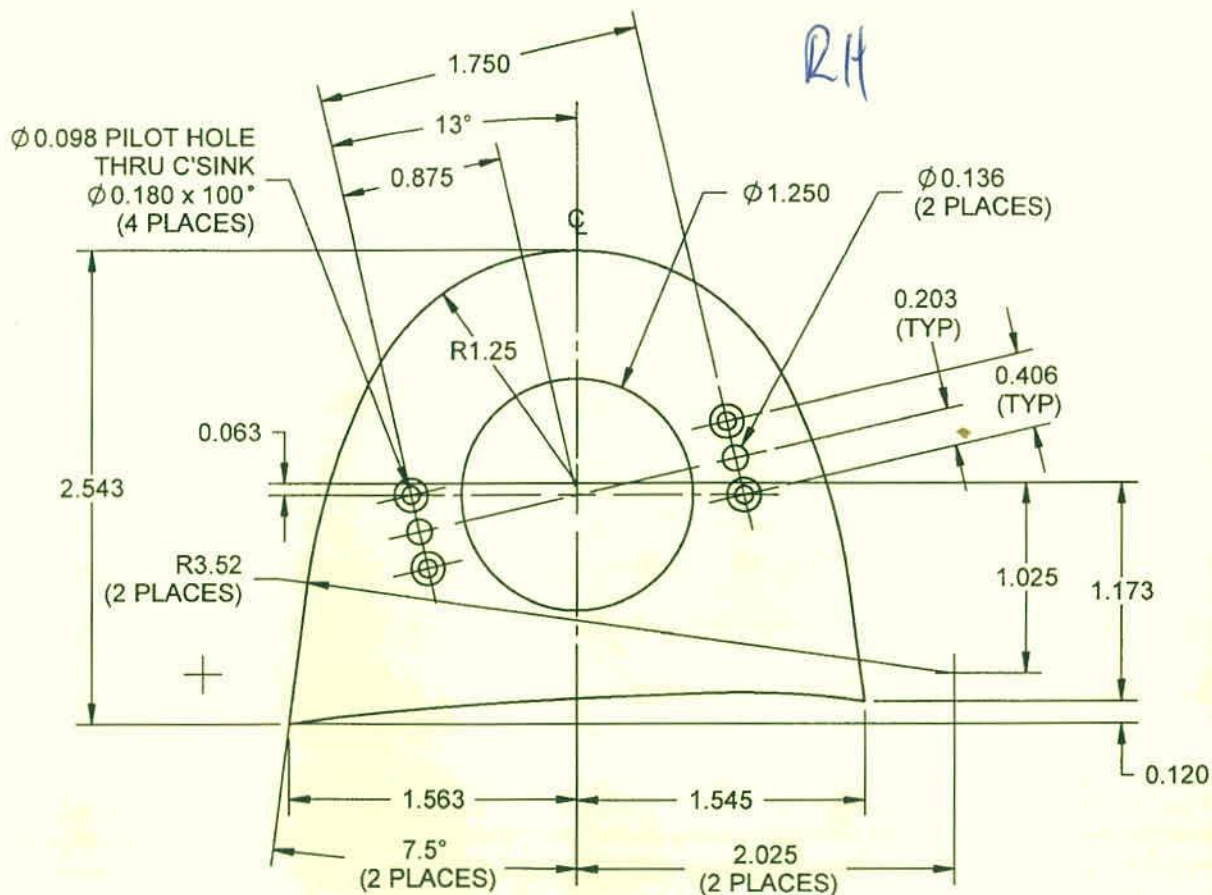
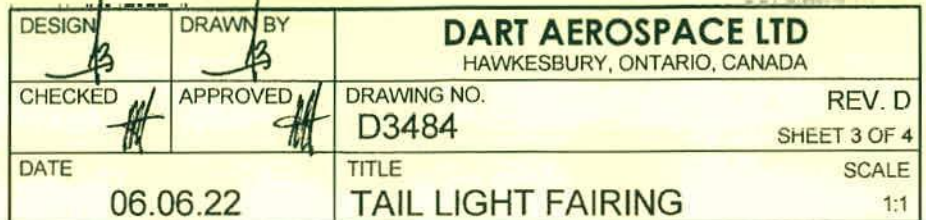
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06.08.17

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 34460

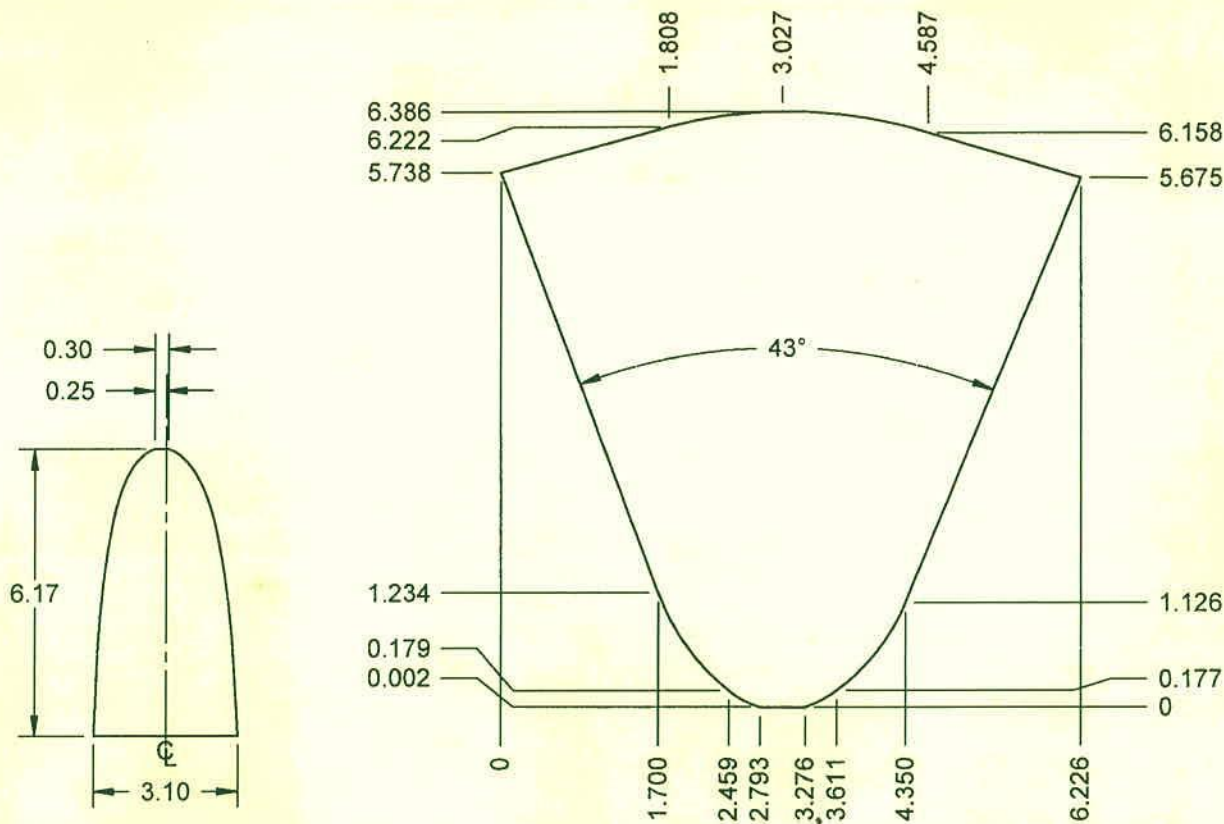
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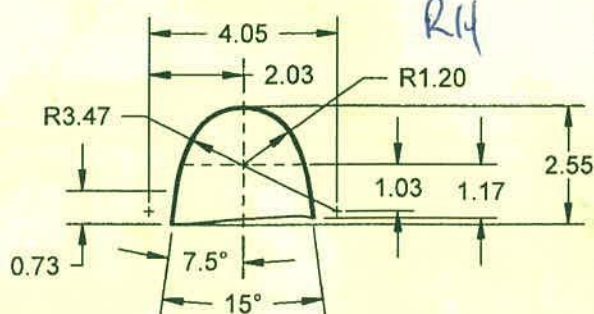
Handwritten signature in blue ink, possibly reading "H. J. P." or similar, located in the lower left corner of the page.



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3484	REV. D SHEET 4 OF 4
DATE 06.06.22		TITLE TAIL LIGHT FAIRING	SCALE 1:4



D3484-5F CONE FLAT PATTERN



D3484-5 L/H CONE BENDING DETAIL (-6 R/H, OPPOSITE)
(MAKE FROM D3484-5F)

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